

Work Order ID 52206

September 17, 2009 2:38:42 PM



Page 1

Item ID: D350-591-122
Revision ID: E
Item Name: Heli-Access-Step, RH

Accept



Setup Start



Stop



Start Date: 9/21/09 Start Qty: 1.00
Required Date: 9/25/09 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2351	Rev E

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and type labels as per PPP D350-591-122 CHG005

0.00

0.00

S. 02/02/22

for BG 09/09/21
(DSI 9459 + new labels only.)
ECN 09-621

290



Packaging

Packaging

Pick Kit

Memo

PULL FROM STOCK:
2 X D350-591-122 B43113
2 X D350-591-122 B46996
4 X D350-591-122 B47624

0.00

0.00

ADD TO EACH KIT D350-591-122:

2 X AN4-16A B 112641 108471
2 X D2732-030 B 98118
PER ECN 09-621

P. 9/15/21 (E)

Work Order ID 52206

September 17, 2009 2:38:42 PM



Page 2

Item ID: D350-591-122

Accept



Setup Start



Revision ID: E

Stop



Item Name: Heli-Access-Step, RH

Start Date: 9/21/09 Start Qty: 1.00



Cust Item ID:

Required Date: 9/25/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

300

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

310

Packaging

0.00



Packaging

Memo

0.00

Packaging

RE-PACKAGE PER PPP
USING NEW B/N
NEW LABELS REQUIRED # CHG005

+ DSI 9459 paper work added

320

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

(x8) f

09/10/09 (8)

09/10/05

09-10-2.

Picklist Print

September 17, 2009 2:38:41 PM

Page 1

Work Order ID: 52206

Parent Item: D350-591-122RevE

Parent Item Name: Heli-Access-Step, RH

Comments:

Start Date: 9/21/09

Required Date: 9/25/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S 46 D2732-030RevB1 2x		Manufactured	No			290	Each	0.0000	2.0000 P/R			
S 46 Rubber Cushion												
AN4-16A 2x		Purchased	No			290	Each	154.0000	2.0000 16 ✓			
S 46 Bolt												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

154

108471

86

112641

50

19278

18

5X 108471
11X 112641

PC 9/21/09 (8)

List Lots

July 28, 2009 10:19:27 AM

Page 1 of 1

Criteria : Item ID: D350-591-122RevE All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID				Lot Code		
D350-591-122RevE Heli-Access-Step, RH	Main Warehouse FG	43113		2.0000	QC21	CHG004	
	Main Warehouse FG	46996		2.0000	QC21	CHG004	
	Main Warehouse FG	47624		4.0000	QC21	CHG004	
Total:				8.0000			

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	Heli-Access-Step™, Short Step – High Skid, LH
	X				D350-591-122	Heli-Access-Step™, Short Step – High Skid, RH
		X			D350-591-123	Heli-Access-Step™, Short Step – Low Skid, LH
			X		D350-591-124	Heli-Access-Step™, Short Step – Low Skid, RH
				X	D350-591-133	Heli-Access-Step™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT

The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.

Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

52206

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: D. SHEPHERD (DE # 02)

DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>90</u>	DART AEROSPACE LTD	
DRAWN	<u>90</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>PL</u>	DRAWING NO.	REV. B
MFG. APPR.	<u>N/A</u>	DSI 9459	SHEET 1 OF 2
APPROVED	<u>MD</u>	TITLE	SCALE
DE APPR.	<u>MD</u>	OPTIONAL CLAMP MODIFICATIONS NTS	
DATE	09.06.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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